

Date: Wednesday, 4/19/2006 7:39:00 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BASKET BASE ASSEMBLY (350)	
Job Number	: 26718A		Part Number	: D2221	
Estimate Number	: 10189		Drawing Number	: D2221/D2235	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 4/19/2006 S.O. No. : N/A		Drawing Revision	: F/B1	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 4/26/2006	
Previous Run	: 26627C			Qty:	1
Written By	<u>: SEE COMMENT Below -</u>			Um:	Each
Checked & Approved By	<u>: SEE ABOVE USER & DATE</u>				
Comment	: Est Rev.J 05.09.02 Added D3442-1KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31661	Basket Hoop	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
	4	D3166-1 RIB <u>B26259</u>	<u>Mo 06/04/19</u>
2.0	D22323	Basket Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
	2	D2232-3 Hinge bracket <u>B25239</u>	<u>Mo 06/04/19</u>
3.0	D2325	Support Gusset (350 Bask)	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
	4	D2325 Support Gusset <u>B25687</u>	<u>Mo 06/04/19</u>
4.0	D23273	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
	2	D2327-3 Bushing <u>B25823</u>	<u>Mo 06/04/19</u>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D2581 Mounting Bracket B26204 /

11/06/04/19

6.0 D34421 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3442-1 Shim A23544 /

11/06/04/19

7.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 39.6900 sf(s)/Unit Total : 39.6900 sf(s)

Pick:

Qty Part Number Description Batch
36 sf M304EX0.75-16F Expanded Metal M100722 /

11/06/04/19

8.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing
Batch: M100704 /

11/06/04/19

9.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

11/06/04/19

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/05/12
 QA: N/C Closed: _____ Date: _____

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Seq. #:

Machine Or Operation:

Description :

10.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

PD

ab-04-25

1

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-05-09

⑥

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL oct/05/09

①

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with white sikaflex-291 Batch: M100901

Expiry date: 11/2006

SAN 06-05-11

①

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DL oct/05/12

⑦

Job Completion



DL 06-05-12

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